

14/14/18 S.F.

DART
AEROSPACE

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RBST2854
Job Sheet 173092

Part No: RBST2854 **Job Qty:** 4 ea

Part Name: Tri Roller Staking Tool

Part Weight: 0 lbs **Status:** Scheduled **Priority:** High

Job Created: 2/26/18 **Job Tracking No:**

Due Date: 4/30/18 **Created By:** Marie Lajeunesse

Type: SOLD **Description:**

Note: DWG RBST2854 Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	4 Ea	4/30/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	4 pcs	4/30/18	0.00	2.00	Small Fab-9		MLL
110	QC	4 pcs	4/30/18	0.00	0.00	QC5		EDS
130	Packaging	4 pcs	4/30/18	0.00	0.00	Packaging3-2		
140	QC21-FG	4 Ea	4/30/18	0.00	0.00	QC21		DAS

Part Op 100 - 1-Assemble as per DWG sheet 1. ***NOTE*** - Apply a light coat of corrosion prevention compound to assembly
Descriptions: (LPS 1/2) See deviation.
130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97705A406	Screw 8-32 X 1/4 S.S. (McMaster)	4 Ea (1 ea)	90-Start up Operation	5036849
RBST2854-1	Roller Fixture	4 Ea (1 ea)	90-Start up Operation	5053744
RBST2854-11	Primary Seat	4 Ea (1 ea)	90-Start up Operation	5059082
RBST2854-13	Secondary Seat	4 Ea (1 ea)	90-Start up Operation	5059084
RBST2854-15	Locating Pin	4 Ea (1 ea)	90-Start up Operation	5058991
RBST2854-17	Locating Pin	4 Ea (1 ea)	90-Start up Operation	5058986
RBST2854-3	Retainer	4 Ea (1 ea)	90-Start up Operation	5059005
RBST2854-5	Roller	12 Ea (3 ea)	90-Start up Operation	5053109
RBST2854-7	Guide	4 Ea (1 ea)	90-Start up Operation	5058599
RBST2854-9	Pin	4 Ea (1 ea)	90-Start up Operation	5060235

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97705A406	4	6	0
	RBST2854-1	4	4	0
	RBST2854-11	4	4	0
	RBST2854-13	4	4	0
	RBST2854-15	4	4	0
	RBST2854-17	4	10	0
	RBST2854-3	4	4	0
	RBST2854-5	12	26	0
	RBST2854-7	4	4	0
	RBST2854-9	4	4	0

Part Specifications

Specifications could not be found.

Plex 4/25/18 3:44 PM dart.logan.david



Container No: S065936



Part: RBST2854

Job No: 173092

Serial No/Batch: S065936

Revision: 1

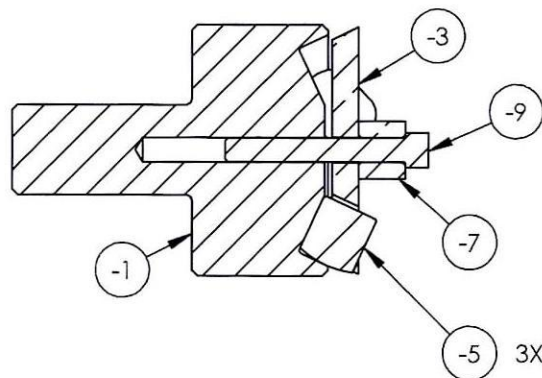
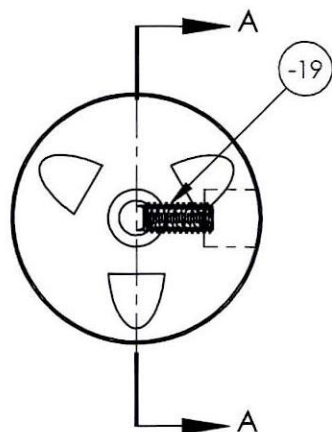
Inspector:

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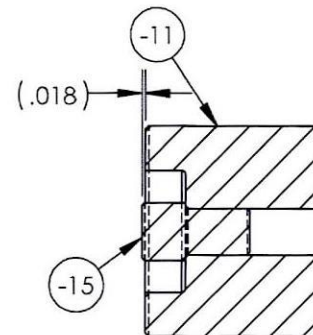
Date: 04/27/18

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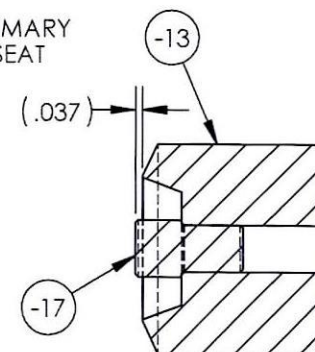
REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1	14-0185	CH'D TITLEBLOCK WAS RED BARN IS DART. -1 CH'D SPECIFICATION WAS Ø1-1/2 X 1-7/8 IS Ø1-3/8 X 1-7/8. CH'D ENGRAVE NOTE, CH'D DIM WAS #8-32 $\sqrt{.675}$ IS #8-32 UNC -28 L $\sqrt{.187}$ $\sqrt{.31}$. -9 CH'D MATERIAL WAS 01 IS STEEL. CH'D SPECIFICATION WAS Ø3/8 X 1-1/8 IS MCMASTER-CARR #98378A909 (MODIFIED). CH'D DIM WAS Ø241 IS (Ø.188), WAS Ø.129 $\pm .000$ -001 IS (Ø.129). -11 CH'D ENGRAVE NOTE. -13 CH'D ENGRAVE NOTE	10/15/2014	DJN	JAG	



SECTION A-A



PRIMARY SEAT



SECONDARY SEAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173092 MLC
1802-26

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ROLLER FIXTURE	DRILL ROD	Ø1-3/8 X 1-7/8	2
			-3	1	RETAINER	BRONZE RND BAR	Ø1-1/2 X 1/4	3
			-5	3	ROLLER	STEEL	GAUGE PIN MSC #89031009	4
			-7	1	GUIDE	BRONZE RND BAR	Ø1/2 X 3/8	5
			-9	1	PIN	STEEL	MCMASTER-CARR #98378A909 (MODIFIED)	6
			-11	1	PRIMARY SEAT	4140 Q & T	Ø1-1/4 X 1-1/8	7
			-13	1	SECONDARY SEAT	4140 Q & T	Ø1-1/4 X 1-1/8	8
			-15	1	LOCATING PIN	1018	Ø3/8 X 3/4	9
			-17	1	LOCATING PIN	1018	Ø3/8 X 3/4	10
		B/O	-19	1	SOCKET HEAD SET SCREW	S.S.	8-32 X 3/8 MCMASTER-CARR #97705A406	1

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$ FRACTIONS $\pm 1/8$.XX $\pm .01$ ANGLES $\pm 5^\circ$.X $\pm .1$	DRAWN BY: GILBERT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 3/29/2011
SHEET 1 OF 10	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
This area is reserved for the description of the deviation and the disposition of the non-conformance.				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					